

Work Order ID 161549

Wednesday, May 17, 2017 2:33:31 PM

161549

Ship May 31

Page 1

Item ID: 41232-200-001-001

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: LH Step Actuator

Start Date: 5/18/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/25/2017 Req'd Qty: 1.00

1

Customer:

Reference:

DAS

21

9-89

Approvals:

Process Plan:

Date: MAY 17 2017

Tooling:

Date:

Run

Start

NR1

QC:

Date:

MAY 17 2017

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

41232-200-001

Rev IR

MAY 26 2017

100

0.00

100

Small Fab

DAS
30
9-89

Small Fab

Memo

0.81

Small Fab

1- Assemble as per Dwg 41232-200-001 2-Torque as per Dwg 41232-200-001

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

DAS
30
9-89

MAY 26 2017

120

Identify as per dwg & Stock Location

0.00

120

Packaging

Memo

0.01

Packaging

DAS
6
9-89

MAY 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Work Order ID 161549***161549***

Page 2

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.10

Quality Control

DAS
21
9-89

MAY 26 2017

DAS
21
9-89

MAY 26 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY							
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Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	
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Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER :							
Misidentified ☐	☐	Past Due	☐								

Picklist Print

Wednesday, May 17, 2017 2:33:34 PM

Page 1

Work Order ID: 161549

161549

Parent Item: 41232-200-001-001

41232-200-001-001

Parent Item Name: LH Step Actuator

Start Date: 5/18/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-02-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
41232-200-002-001		Manufactured	No			100	Each	18.0000	1	DAS 30 9-89		MAY 26 2017	
41232-200-002-001									**				

Tube

Location	Loc Qty	Loc Code
ST598	5	
105453	5	
ST599	13	
107897	13	

41232-200-002-003		Manufactured	No			100	Each	15.0000	1	DAS 30 9-89		MAY 26 2017	
41232-200-002-003									**				

Latch

Location	Loc Qty	Loc Code
ST599	15	
107899	5	
109905	10	

41232-200-002-005		Manufactured	No			100	Each	19.0000	1	DAS 30 9-89		MAY 26 2017	
41232-200-002-005									**				

Pivot Arm

Location	Loc Qty	Loc Code
ST599	19	
107898	9	
109906	10	

41232-200-005-003		Manufactured	No			100	Each	6.0000	2	DAS 30 9-89		MAY 26 2017	
41232-200-005-003									**				

Spacer (Step Actuator)

Location	Loc Qty	Loc Code
ST600	6	
134069	6	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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Wednesday, May 17, 2017 2:33:34 PM

Page 2

Work Order ID: 161549

161549

Parent Item: 41232-200-001-001

41232-200-001-001

Parent Item Name: LH Step Actuator

Start Date: 5/18/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

AN315-4R	Purchased	No	100	Each	83.0000	1	1	DAS 30 9-89	MAY 26 2017
AN315-4R						**			
Nut									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST331	83	
M128978	83	

AN3-22A	Purchased	No	100	Each	15.0000	1	1	DAS 30 9-89	MAY 26 2017
AN3-22A						**			
Bolt									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST348	15	
110998	15	

AN842-4D	Purchased	No	100	Each	10.0000	1	1	DAS 30 9-89	MAY 26 2017
AN842-4D						**			
Elbow									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST323	5	
M122170	5	
ST324	5	
M127290	5	

D3975-041	Manufactured	No	100	Each	9.0000	1	1	DAS 30 9-89	MAY 26 2017
D3975-041						**			
Gas Cylinder Assembly, LH									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST063	9	
101882	1	
61798	3	
87621	5	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
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Wednesday, May 17, 2017 2:33:34 PM

Page 3

Work Order ID: 161549

161549

Parent Item: 41232-200-001-001

41232-200-001-001

Parent Item Name: LH Step Actuator

Start Date: 5/18/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

MS16996-23

Purchased

No

100

Each

399.0000

1

1

DAS
30
9-89

MS16996-23

cap screw

**

Location

Loc Qty

Loc Code

ST316

399

112492

399

1

DAS
30
9-89

MS20822-4

Purchased

No

100

Each

5.0000

1

1

**

MS20822-4

elbow

Location

Loc Qty

Loc Code

ST305

5

m126275

5

1

DAS
30
9-89

MS21042L3

Purchased

No

100

Each

2,010.000

1

1

**

MS21042L3

Nut

Location

Loc Qty

Loc Code

CCK007

1000

m137495

1000

FP001

91

m135945

91

GA

464

m134360

102

M136665

362

ST303

455

m137321

455

MAY 26 2017

MAY 26 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
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Page 4

Work Order ID: 161549

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Parent Item: 41232-200-001-001

41232-200-001-001

Parent Item Name: LH Step Actuator

Start Date: 5/18/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

100

Each

386.0000

2

2

DAS
30
9-89

NAS1149D0363.J

Washer

**

MAY 26 2017

Location

Loc Qty

Loc Code

GA

13

m134055

13

ST263

373

m137164

373

2

NAS1149D0463J

Purchased

No

100

Each

3,908.000

2

2

DAS
30
9-89

NAS1149D0463.J

Washer

**

MAY 26 2017

Location

Loc Qty

Loc Code

GA

48

M135056

48

ST260a

2000

M137371

2000

ST263

1860

M137381

1860

2

S-1455

Purchased

No

100

Each

47.0000

1

1

DAS
30
9-89

S-1455

Spring-Step Actuator (Replaces 71459)

**

MAY 26 2017

Location

Loc Qty

Loc Code

ST571

47

110154

34

111342

13

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			